



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T101530-3
Job Sheet 188952



Part No: RB T101530-3

Job Qty: 2 pcs

Part Name: Bearing Roll Stake Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101530 Rev.A IPP Rev. A 18.05.30 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	2/8/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	2/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	2/8/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S155593



Part: RB T101530-3

Job No: 188952

Serial No/Batch: S155593

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/21/19

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLL
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	2 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	DAS 21 FEB 21 2019 GA
					QC 21 - SA - 70	
Part Op 110 - Small Fab - 1-Assemble as per DWG. See note 8 & 9. Descriptions: 120 - QC5- Inspect part completeness to step on W/O 130 - Identify as per dwg & Stock Location: _____ Bag and tag. See note 10. 140 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MS21042-4	Nut	2 Ea (1 ea)	110-Small Fab - 1			
RB T101530-11	Bearing Roll Stake Roller	4 pcs (2 ea)	110-Small Fab - 1			
RB T101530-13	Base	2 Ea (1 ea)	110-Small Fab - 1			
RB T101530-15	Bolt	2 Ea (1 ea)	110-Small Fab - 1			
RB T101530-7	Bearing Roll Stake Body	2 Ea (1 ea)	110-Small Fab - 1			
RB T101530-9	Roller	4 pcs (2 ea)	110-Small Fab - 1			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Small Fab - 1	MS21042-4	2	42	0		
	RB T101530-11	4	0	0		
	RB T101530-13	2	8	0		
	RB T101530-15	2	0	0		
	RB T101530-7	2	0	0		
	RB T101530-9	4	8	0		
Part Specifications						
Specifications could not be found.						



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Part Name: Bearing Roll Stake Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101530 Rev.A IPP Rev. A 18.05.30 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/8/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	2 pcs		2/8/19	0.00	2.00	Small Fab-3		
120	QC	2 pcs		2/8/19	0.00	0.00	QC5		
130	Packaging	2 pcs		2/8/19	0.00	0.00	Packaging3-1		
140	QC21-SA	2 Ea		2/8/19	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG. See note 8 & 9.
Descriptions: 130 - Bag and tag. See note 10.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T101530-7	Bearing Roll Stake Body	2 Ea (1 ea)	90-Start up Operation	5147811
MS21042-4	Nut	2 Ea (1 ea)	110-Small Fab	5038763
RB T101530-11 - PO	Bearing Roll Stake Roller	4 Ea (2 ea)	110-Small Fab	3099105
RB T101530-13 pkg	Base	2 Ea (1 ea)	110-Small Fab	5151953
RB T101530-15	Bolt	2 Ea (1 ea)	110-Small Fab	5148420
RB T101530-9	Roller	4 pcs (2 ea)	110-Small Fab	5066659

Job Allocations

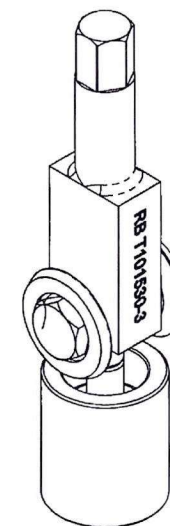
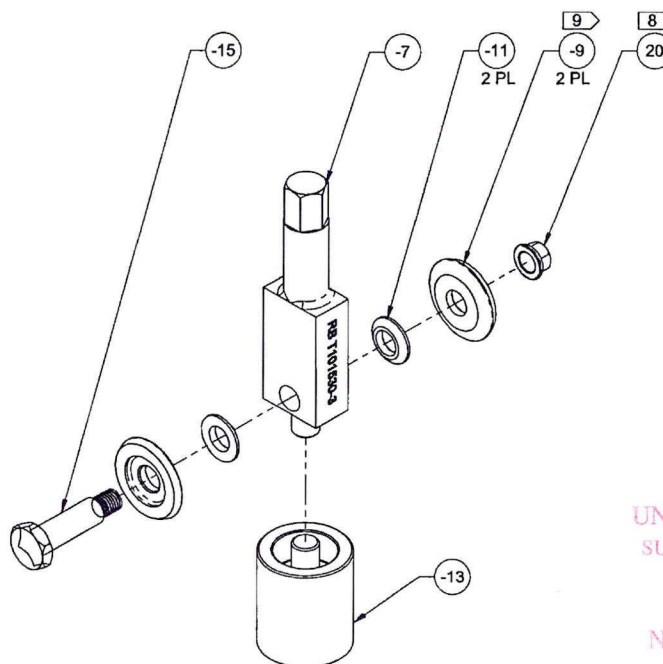
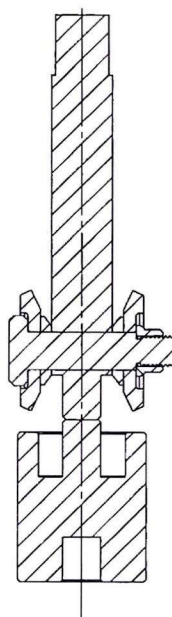
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB T101530-7	2	0	0
110-Small Fab	MS21042-4	2	42	0
	RB T101530-11	4	0	0
	RB T101530-13	2	8	0
	RB T101530-15	2	0	0
	RB T101530-9	4	8	0

Part Specifications

Specifications could not be found.

Plex 1/17/19 7:53 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-7	1	RB T101530-7	BODY
-9	2	RB T101530-9	ROLLER
-11	2	RB T101530-11	SPACER
-13	1	RB T101530-13	BASE
-15	1	RB T101530-15	BOLT
20	1	MS21043-4	1/4"-28 LOCKNUT, STAINLESS STEEL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188952 MWS
19-01-17

RB T101530-3 BEARING ROLL STAKE TOOL (10)

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN, TORQUE ITEM 20 TO 50-70 IN/LBS.
 - 9) ITEMS -9 MUST ROTATE FREELY.
 - 10) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG.

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	MKE	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 2 OF 10
APPROVED	MKE	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					